

# Work Order ID 51710

August 28, 2009 8:21:35 AM

Page 1

Item ID: D2282-041

Accept

Revision ID: E

Item Name: T Assembly

Start Date: 8/31/09 Start Qty: 50.00

Required Date: 9/04/09 Req'd Qty: 50.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly ☐ Grind chamfers and ensure full penetration as per dwg D2282 ☐ \*\*\*\*\*brush weld right after welding, to take color off \*\*\*\*\* ☐ A/RER316L SS Filling Rod

~~M102421~~  
M109213

SM 09/10/09

50x

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.10.09

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

B 9-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D2282-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: T Assembly

Start Date: 8/31/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

=> 50/10/13

count  
(50)

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 57261 0.00

0.00

Packaging

Memo

Packaging

09/10/13 (50)

150

QC21- Final Inspection - Work Order Release 0.00

0.00

QC

Memo

Quality Control

09/10/14

MR

09-10-14

# Picklist Print

Page 1

August 28, 2009 8:21:34 AM

Work Order ID: 51710

Parent Item: D2282-041RevE

Parent Item Name: T Assembly





Comments:

Start Date: 8/31/09

Required Date: 9/04/09

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status		
D2282-3RevE 		Manufactured	No			100	Each	0.0000	50.0000 	351725 → 50x		24 09/10/09		
Tube D2282-5RevE 		Manufactured	No			100	Each	34.0000	50.0000 	B 48281 → 34x		24 09/10/09		
Tube										B 51726 → 16x		24 09/10/09		
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>				
				<u>Location</u>										
				Main Warehouse										
				ST				34						
				48281				34						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

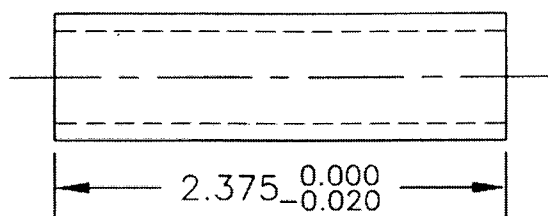
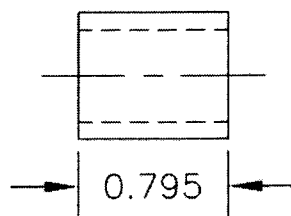
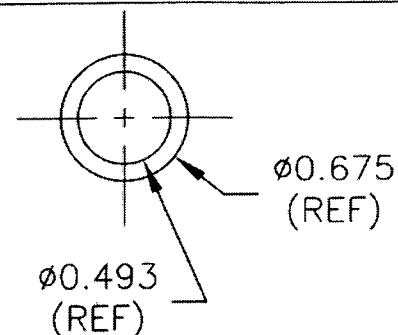
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

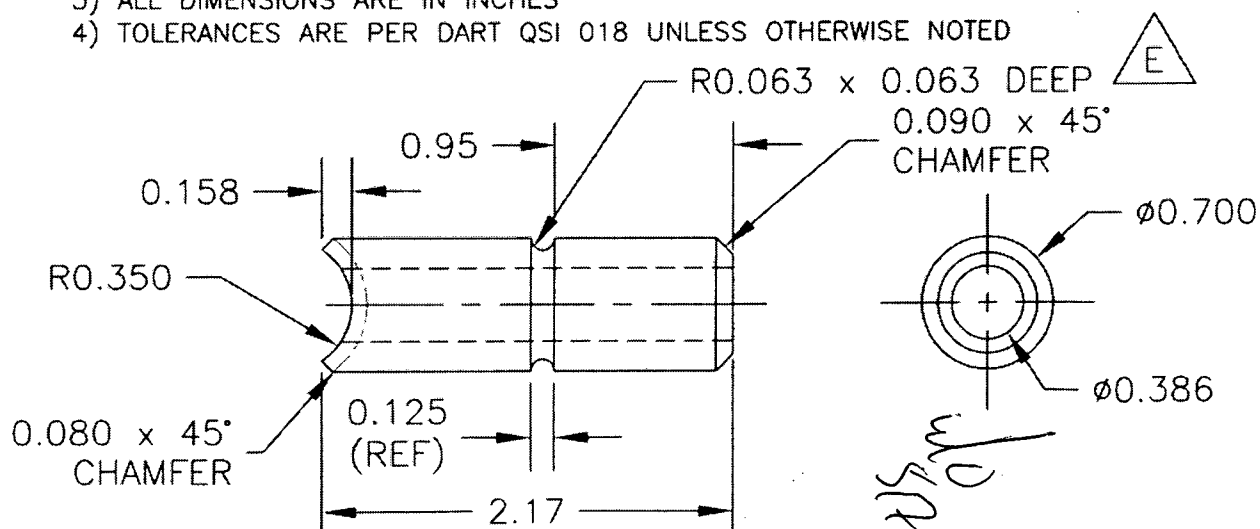
**NOTE:** Date & initial all entries

**DART**

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**RELEASED***05/09/16***D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

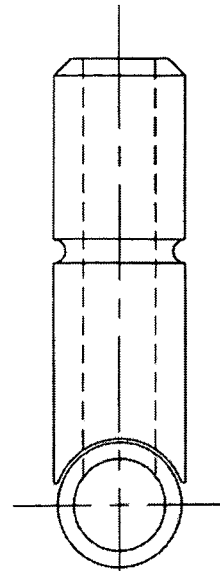
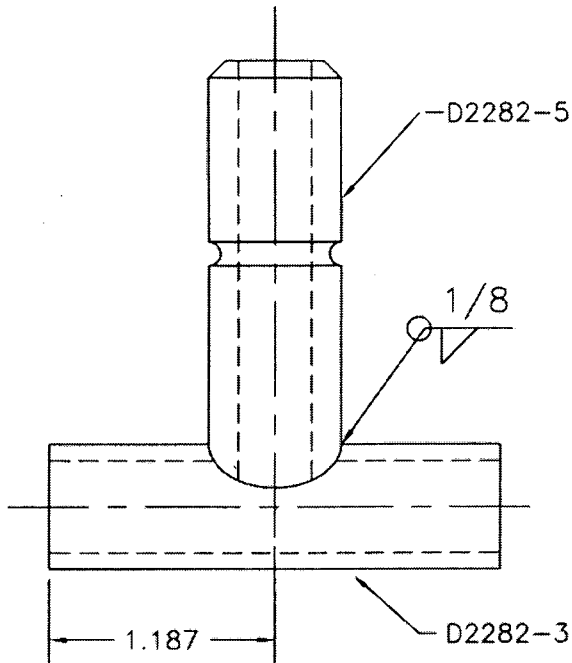
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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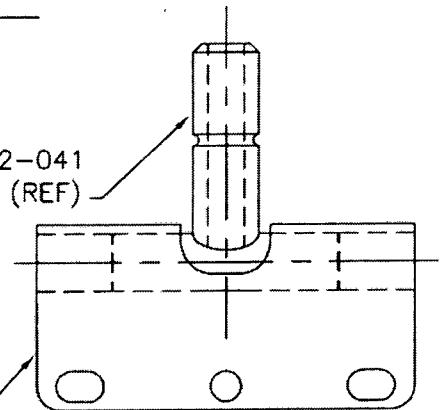
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



RECEIVED  
05/09/16

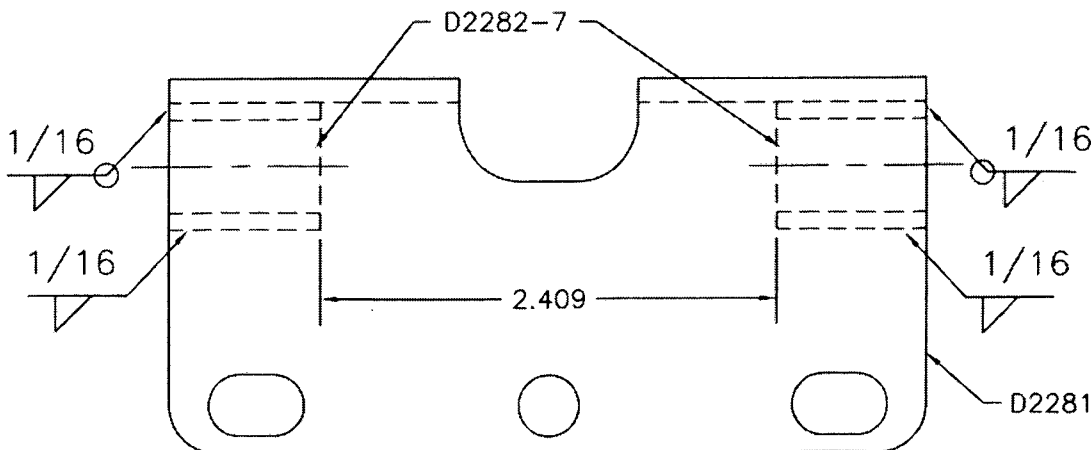
**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

D2282-041  
(REF)



**GENERAL ASSEMBLY**  
SCALE 1:2

51710



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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